

Work Order ID 117637

Tuesday, April 29, 2014 10:20:51 AM

117637

Page 1

Item ID: D3910-5 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Crosstube Lug
 Start Date: 4/29/2014 Start Qty: 80.00 *80* Cust Item ID:
 Required Date: 5/9/2014 Req'd Qty: 80.00 *80* Customer:
 Reference:

Approvals: Process Plan: CX Date: 14/04/29 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3910	D

110	Outsource process - Machining	0.00							
110	HAAS CNC VERTICAL MACHINING #1								
Outsource5	Memo	0.00							
Outsource process - Machining	Issue P/O to ATG; <u>24013</u> MANUFACTURE AS PER DWG C of C is required								

120	Receive & Inspect for Damage & Mat'l Certs	0.00							
120									
Packaging	Memo	0.00							
Packaging	Ensure C of C is attach								

130	QC6- Inspect dimensions to drawing	0.00							
130									
QC	Memo	0.00							
Quality Control									

135
145

Hand finish Acid Etch + Abbrise ——— 61 14-5-5
 QC 7 ————— 61 14-5-6.

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 Start Date: 4/29/2014 Start Qty: 80.00 *80* Cust Item ID:
 Required Date: 5/9/2014 Req'd Qty: 80.00 *80* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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18#

180

Packaging

Packaging

Identify as per dwg & Stock Location: 5459 0.00

Memo

0.00

61X 14-5-7

DAS
26
9-89

190

190

QC

Quality Control

QC21- Final Inspection - Work Order Release 0.00

Memo

0.00

MLJ 14-05-08

14-05-08

61 14-5-6

DAS
34
9-89

powdercoat white per Q51005
m128029
START: 11:30
QUEN. T: 320°
FINISH: 12:00

QC3

61 *14/05/06*

Picklist Print

Tuesday, April 29, 2014 10:20:50 AM

Page 1

Work Order ID: 117637

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Parent Item: D3910-5

D3910-5

Parent Item Name: Crosstube Lug

Start Date: 4/29/2014

Required Date: 5/9/2014

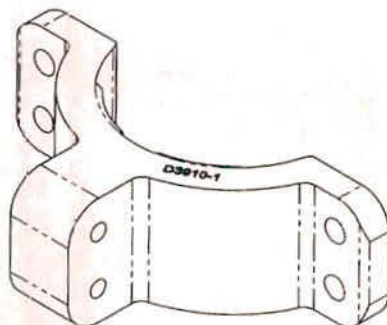
Start Qty: 80.00

Required Qty: 80.00

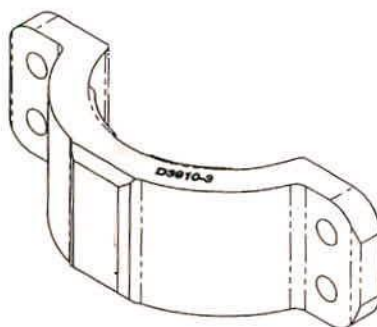
Comments: IPP REV:A 13.02.28 NEW ISSUE DD VERF:JFS
13.09.26 AS PER REV.D DD VERF:JLM

IPP REV:B

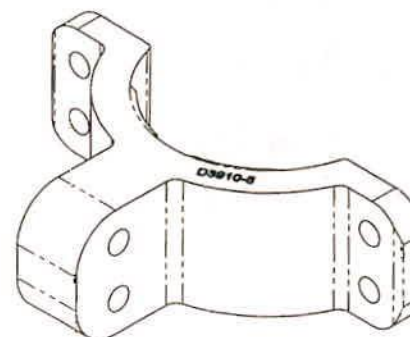
[illegible]



D3910-1 X-TUBE LUG



D3910-3 X-TUBE LUG



D3910-5 X-TUBE LUG

CLY/04/29
WLO: 117637

RELEASED
2013-09-23

NOTES:

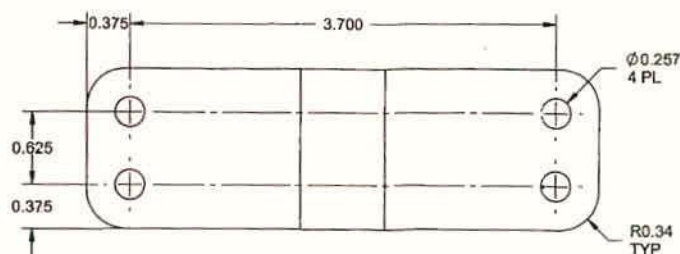
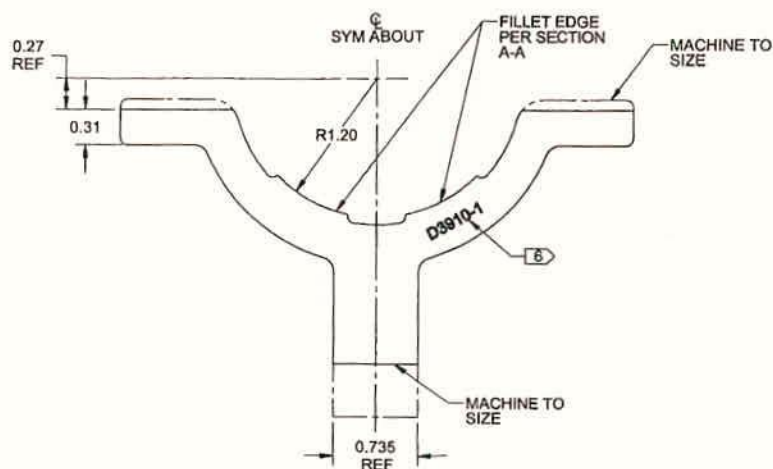
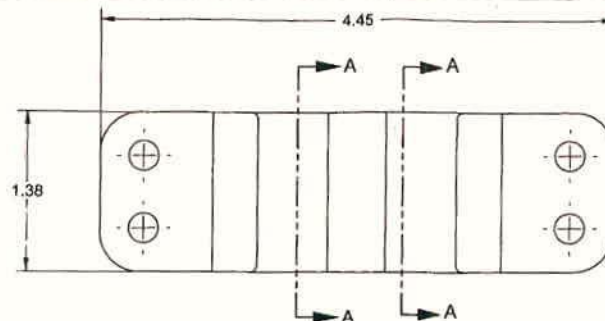
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION WITH A TOOL TIP RADIUS OF 0.015 ± 0.005
- 7) WEIGHT -1: 0.32 lbs
-3: 0.25 lbs
-5: 0.36 lbs

D	CHANGED FASTENER HOLES IN .5 FOR 1/4" HARDWARE. REASON: EASE OF INSTALLATION.	AJS	13.08.14
C	ADD .5.	AJS	13.08.08
B	20.257 HOLES: 4 PL WAS 2 PL (A3-2) & (A3-3); R0.3" FILLET WAS R0.50 (A3-2) & (A3-3). REASON: SEE TR-D390-507-2	JPH	10.03.16
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. D
MFG. APPR.	2/	D3910	SHEET 1 OF 4
APPROVED	4/	TITLE	SCALE
DE APPR.	4/	X-TUBE LUG (350)	NTS
DATE	13.08.14	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

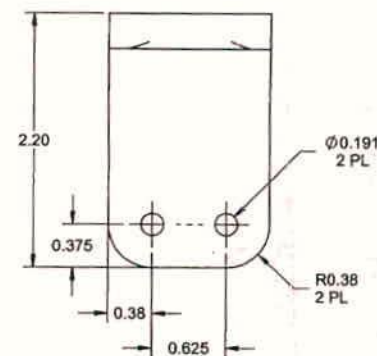


ROUND EDGE
R0.06 MIN - R0.10 MAX
2 PL

SECTION A-A



D3910-1 X-TUBE LUG



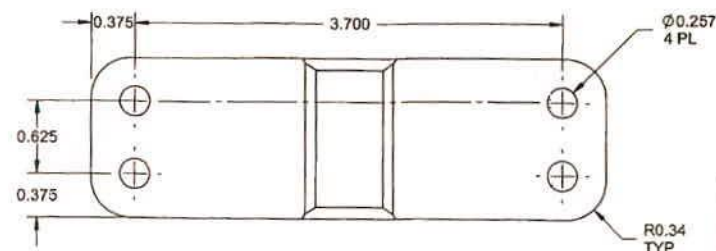
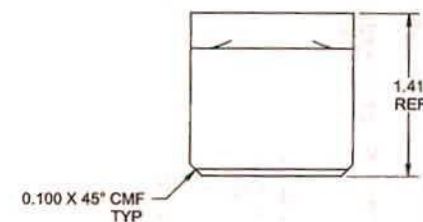
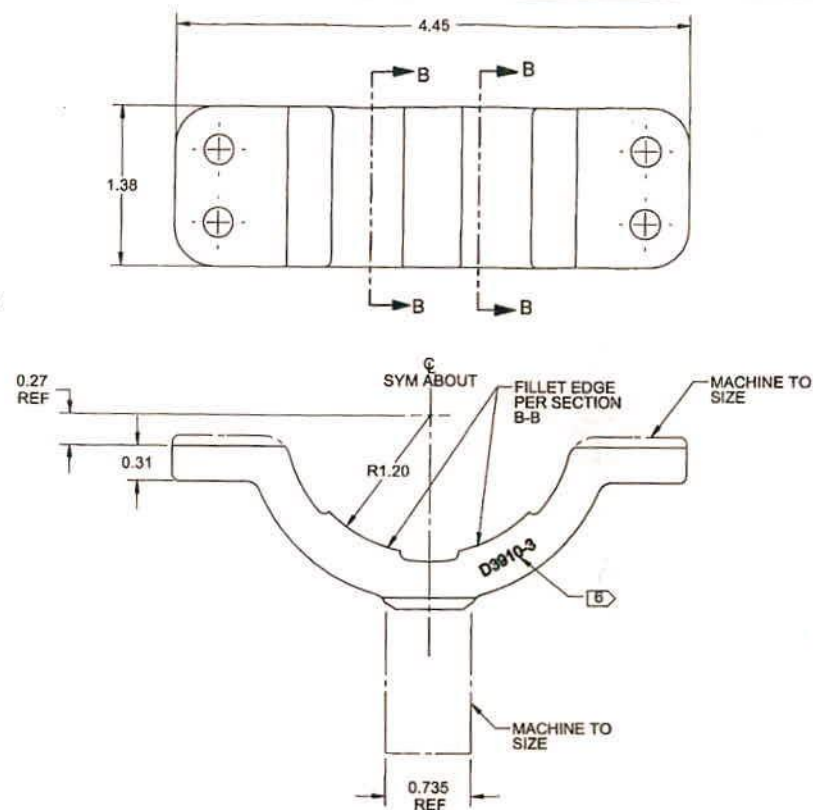
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DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	AJS	DRAWING NO. D3910	REV. D
MFG. APPR.	<i>[Signature]</i>	TITLE X-TUBE LUG (350)	SHEET 2 OF 4
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DE APPR.	<i>[Signature]</i>	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	13.08.14		



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL

SECTION B-B



D3910-3 X-TUBE LUG

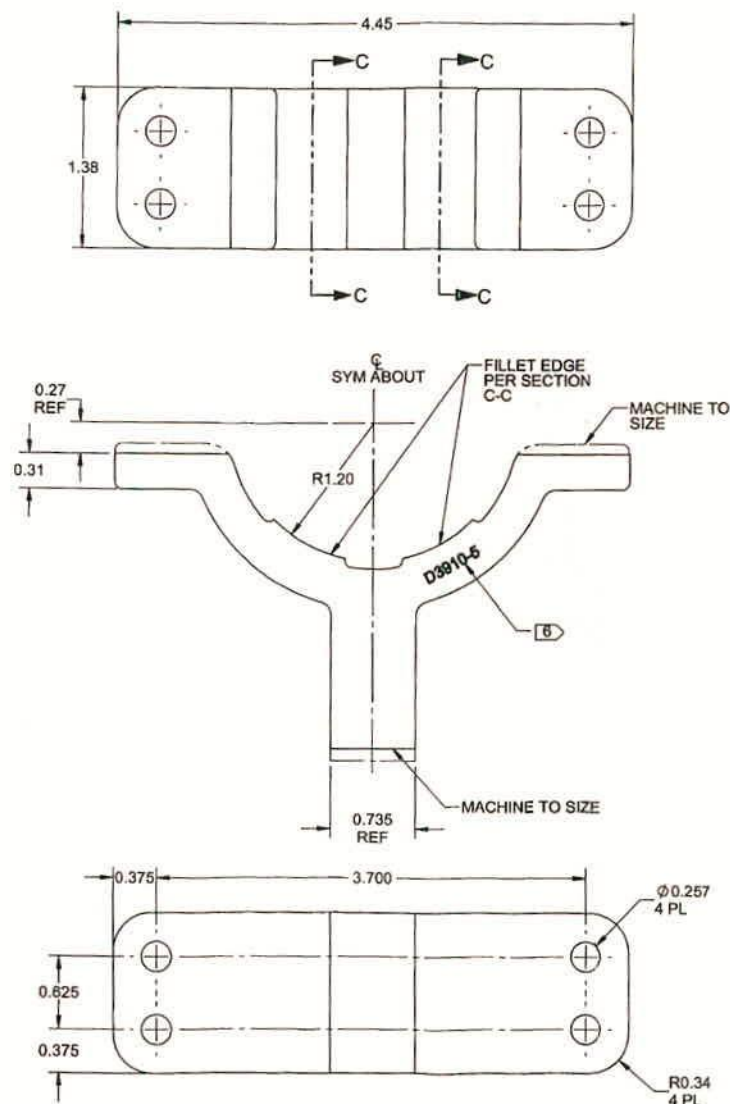
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2013-09-23
MP

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	A.P.	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3910	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	X-TUBE LUG (350)	NTS
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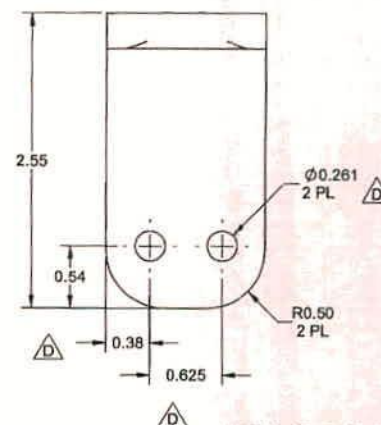
SECTION C-C



ROUND EDGE
R0.06 MIN - 0.10 MAX
2 PL



D3910-5 X-TUBE LUG



RELEASED
2013-09-23

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AJS	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3910	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	X-TUBE LUG (350)	NTS
DATE	13.08.14	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO24013**

Purchase Order Date 4/30/2014

PO Print Date 5/2/2014

Page Number 1 of 2

Order From :

VC-MET003

METEC METAL TECHNOLOGY INC.
20 TERRY FOX DRIVE PO BOX 781
VANKLEEK HILL, ON K0B 1R0
CA

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

REVISED \$

Contact Name

Vendor Phone 613 678 3957

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

CAD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3910-5P MACHINE AS PER DWG D3910 REV. D B117637	Crosstube Lug	5/9/2014 Yes 5/9/2014		80.00 Each <i>W461</i> <i>1/214/5/2</i>	\$15.77	\$1,261.60
Line Total:							\$1,261.60
2	71401-45 Procurement Quality Clauses A004 faa-pma/tso A005 right of entry A007 first article inspection A016 personnel qualification A026 certification of materila conformance A040 notification of escape clauses A042 dart notification by supplier A043 retention of quality document	PROCUREMENT QUALITY CLAUSES	5/9/2014 No 5/9/2014		1.00	\$0.00	\$0.00

Note:

5/2/2014



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: 19982
Date: May 02, 2014
Page: 1

Sold to: Dart Aerospace Ltd. Att. Micheal Gregoire 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Micheal Gregoire 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: 24013	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date: May 02, 2014

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D3910-5P Crosstube Lug	Each	80	61	19
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
61	D3910-5	Crosstube Lug	PO 24013

MATERIAL: supplied by DART B105422

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in blue ink, appearing to read "Jan Norris", is written over the printed name.

Jan Norris

Vankleek Hill, May 2, 2014